

Work Order ID 131152

131152

Page 1

March-26-15 1:45:39 PM

Item ID: D3945-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 3/26/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-03-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3945	A

100		0.00							
100									
Waterjet	Memo	0.00							

FLOW CNC Waterjet

1-Cut as per Dwg D3945-1
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

⑧ DL 15/04/04

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

⑧ DL 15/04/04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Page 2

Reference:

Stop *NR2*

APR 06 2015

DAS
28 APR 06 2015
9-89

15/04/06

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WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

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Reference:

Stop *NR2*

Quality Control

DAS
38
9-89

APR 06 2015

Hand Finishing

DAS
28

9-89

APR 07 2015

Quality Control

**DAS
30
9-89**

15 6467

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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PS-4-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Transport									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:45:38 PM

Page 1

Work Order ID: 131152

131152

Parent Item: D3945-041

D3945-041

Parent Item Name: Bracket

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

195.3777

0.0118

1

M6061T6S 050

6061-T6 .050 Sheet

215/04/04

Location

Loc Qty

Loc Code

MAT021 128408

195.3777

.5

125636

11.3777

m131352

184

MS21059L3

Purchased

No

180

Each

205.0000

1

4

MS21059L 3

Nut Plate

DAS
28
9-89

APR 07 2015

Location

Loc Qty

Loc Code

CA

16

M129682

16

GA

11

113749

3

M130823

8

ST303

178

M131616

178

MS20426AD3-3

Purchased

No

180

Each

5,192.000

2

8

MS20426AD3-3

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

ST313

5192

M131624

5192

8

DQA: _____ Date: _____



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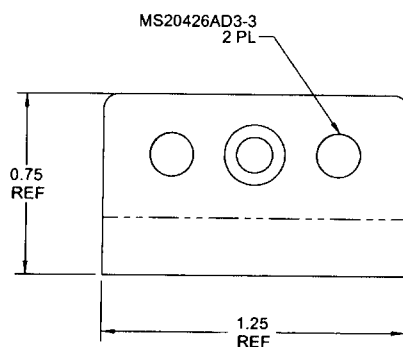
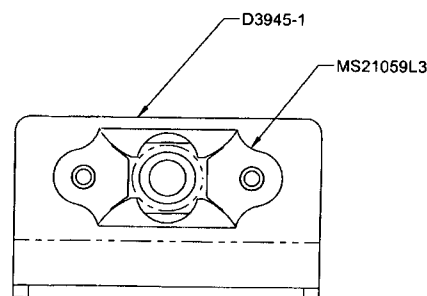
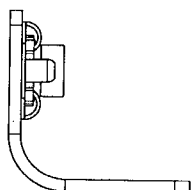
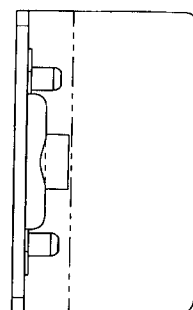
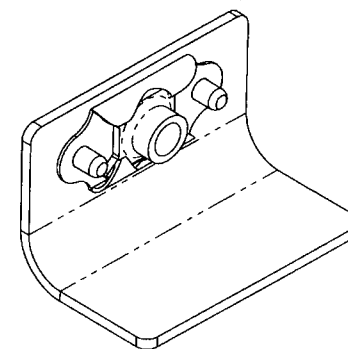
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PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET

**D3945-041 BRACKET**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

131152 MJS

15-03-31

RELEASED
09/06/16

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3945		SHEET 1 OF 3	
TITLE BRACKET		SCALE NTS	
COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

D

C

B

A

D

C

B

A

8

7

6

5

4

3

2

1

8

7

6

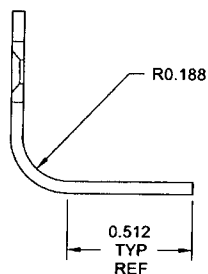
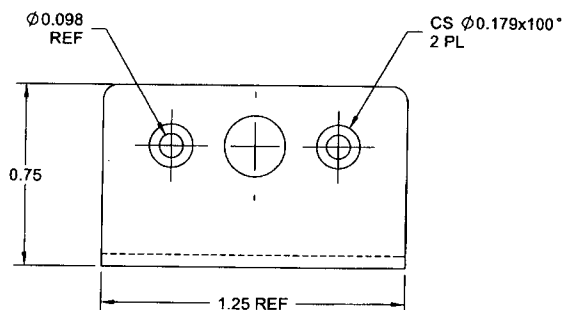
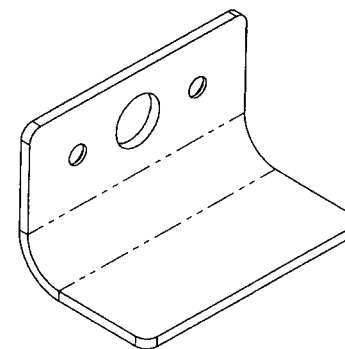
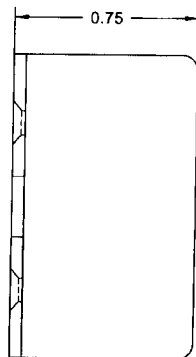
5

4

3

2

1



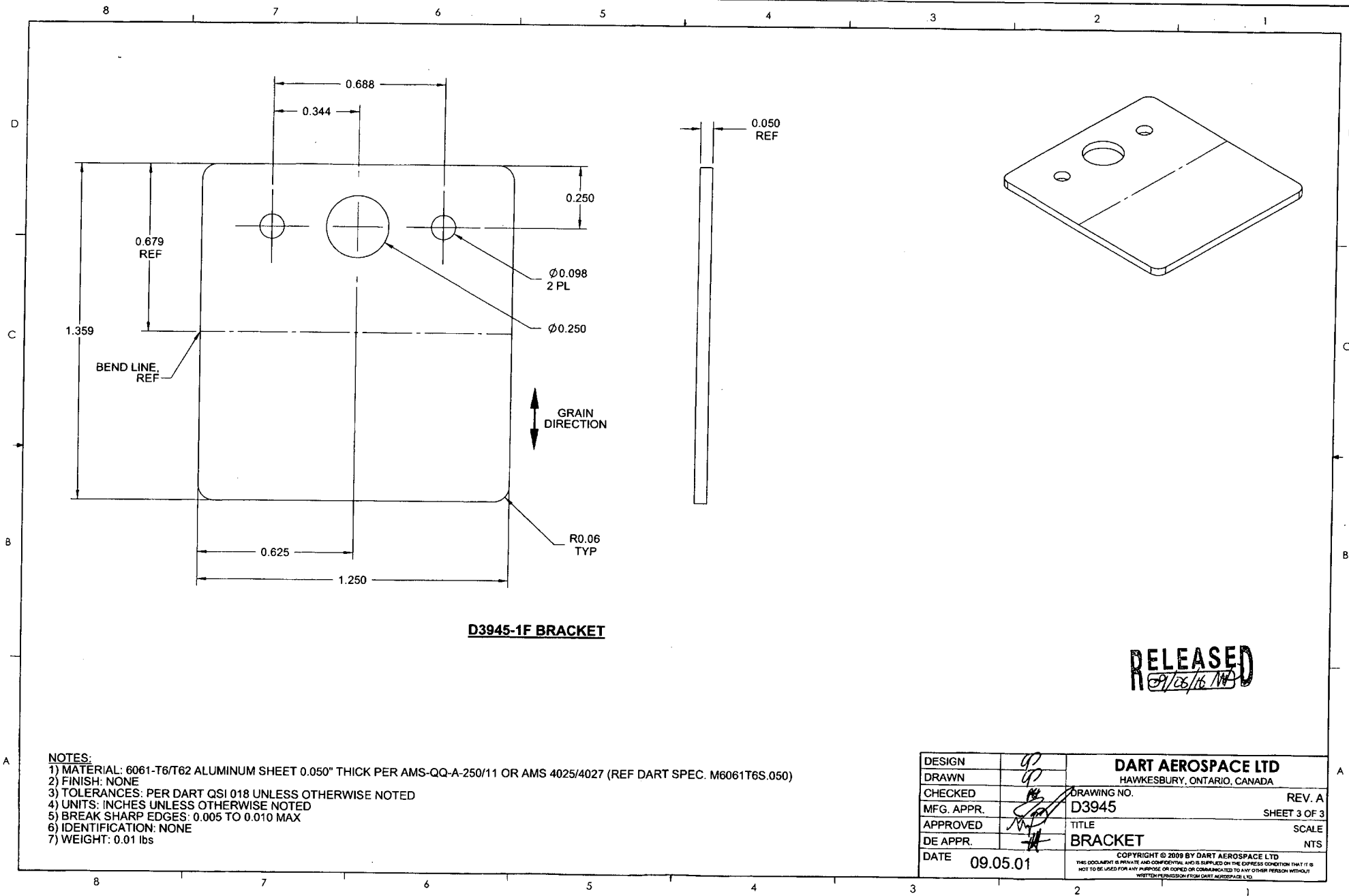
D3945-1 BRACKET

RELEASED
09/06/16

NOTES:

- 1) MATERIAL: MAKE FROM D3945-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO. D3945	REV. A
MFG. APPR.	92	SHEET 2 OF 3	
APPROVED	92	TITLE BRACKET	SCALE NTS
DE APPR.	92	DATE 09.05.01	
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D3945-1F BRACKET

RELEASED
09/05/01

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.050" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.050)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.01 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO. D3945	REV. A
MFG. APPR.	92	TITLE	SHEET 3 OF 3
APPROVED	92	BRACKET	SCALE
DE APPR.	92		NTS
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